

**AMENDMENTS TO THE CLAIMS WITH MARKINGS TO SHOW CHANGES  
MADE, AND LISTING OF ALL CLAIMS WITH PROPER IDENTIFIERS**

Claims 1-19 (Canceled)

20. (New) A metallic tube portion, produced from a single-piece tube, for a tube coil, which tube portion includes at least two tube bends, wherein the tube portion consists of one of the DIN EN 10027 part 1 materials GX40CrNiSi25-20, GX40NiCrSiNb35-25, GX45NiCrSiNbTi35-25, GX35CrNiSiNb24-24, GX45NiCrSi35-25, GX43NiCrWSi35-25-4, GX10NiCrNb32-20, GX50CrNiSi30-30, G-NiCr28W, G-NiCrCoW, GX45NiCrSiNb45-35, GX13NiCrNb45-35, GX13NiCrNb37-25, GX55NiCrWZr33-30-04.
21. (New) The tube portion as claimed in claim 20, characterized in that the longitudinal axis of individual subsections of the tube portion does not run in one plane between two ends of the tube portion.
22. (New) The tube portion as claimed in claim 20, characterized in that the ratio of bending radius to tube diameter of a tube bend, at least in sections, is less than 1.5.

23. (New) The tube portion as claimed in claim 22, characterized in that the ratio of bending radius to tube diameter of a tube bend, at least in sections, is less than 1.1, in particular less than or equal to 1.04.
24. (New) The tube portion as claimed in claim 20, characterized in that the intermediate length between two tube bends is less than 300 mm.
25. (New) The tube portion as claimed in claim 24, characterized in that the intermediate length between two tube bends is less than or equal to 40 mm.
26. (New) The tube portion as claimed in claim 20, characterized in that the tube portion has a substantially constant wall thickness.
27. (New) The tube portion as claimed in claim 26, characterized in that the wall thickness of the entire tube portion is between 6 mm and 14 mm.
28. (New) The tube portion as claimed in claim 20, characterized in that the inner surface of the tube portion, at least in sections, has a roughness of less than 12  $R_a$ .
29. (New) The tube portion as claimed in claim 28, characterized in that the inner surface of the tube portion, at least in sections, has a roughness of less than 3.2  $R_a$ .

30. (New) A tube coil for a chemical plant, which is assembled from tubes connected to one another by at least one tube portion, characterized by at least one tube portion as claimed in claim 20 connected to one of the tubes at least at one of its ends.
31. (New) The tube coil as claimed in claim 30, characterized in that the tube portion, at least at one of its ends, is connected to a tube or tube portions which is/are produced from the same material.
32. (New) A process for producing a tube portion as claimed in claim 20, characterized in that the tube portion is produced from a centrifugally cast tube.
33. (New) The process as claimed in claim 32, characterized in that the centrifugally cast tube is deformed by inductive bending.
34. (New) The process as claimed in claim 33, characterized in that the centrifugally cast tube is heat-treated prior to the inductive bending.
35. (New) The process as claimed in claim 34, characterized in that the centrifugally cast tube is subjected to a heat treatment at a temperature of 800°C to 1200°C prior to the inductive bending operation.

36. (New) A process for producing a tube coil as claimed in claim 31, characterized in that the tube portion is produced from a centrifugally cast tube.
37. (New) The process as claimed in claim 36, characterized in that the centrifugally cast tube is deformed by inductive bending.
38. (New) The process as claimed in claim 37, characterized in that the centrifugally cast tube is heat-treated prior to the inductive bending.
39. (New) The process as claimed in claim 38, characterized in that the centrifugally cast tube is subjected to a heat treatment at a temperature of 800°C to 1200°C prior to the inductive bending operation.
40. (New) Fitting substitute for a tube coil with fittings, characterized by a metallic tube portion as claimed in claim 20.
41. (New) Cracker with a metallic tube portion as claimed in claim 20.
42. (New) Cracker with a tube coil as claimed in claim 30.